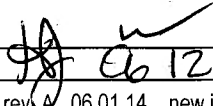
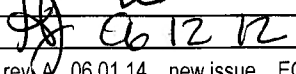


Date: Tuesday, 12/12/2006 10:31:52 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RIGHT ARM WELDMENT
 Job Number : 29903
 Estimate Number : 11875
 P.O. Number : N/A Part Number : D33545
 This Issue : 12/12/2006 S.O. No. : N/A Drawing Number : D3354 REV.A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 27657 Material : N/A
 Due Date : 1/10/2007 Qty: 10 Um: Each
 Written By : 
 Checked & Approved By : 
 Comment : est rev. 06.01.14 new issue EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010B0750X0200 1010-1025 BAR



Comment: Qty.: 0.4148 f(s)/Unit Total: 4.1475 f(s)

1010-1025 BAR

AISI 1010-1025 Steel bar 2.00" x 0.750" Batch: M15925

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 4.625" long

JL 06/12/19 (10)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA612 and Dwg D3353

2- Debur

JL 06/12/20

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 06/12/20

5.0 QC8 SECOND CHECK



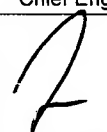
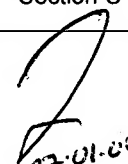

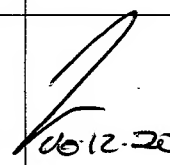
Comment: SECOND CHECK

rnk 06/12/20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3354-5 PAR #: N/A Fault Category: CNC NCR: Yes No DQA: A Date: 07.01.05
 QA: N/C Closed: A Date: 07.01.05

NCR: 29903		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/20	3	- 3 parts scraped - 1 part is short of .060 - 1 part $\phi 1.250^{+0.05}_{-0.01}$ is .002 over - 1 part holes are .005 too small, can not re-bore	 Q51042	- scrap + replace.	J.L. 06/12/20	 07-01-04	 Q51042	 0612-20

NOTE: Date & initial all entries



Date: Tuesday, 12/12/2006 10:31:52 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 29903

Part Number: D33545

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Cpl 07-01-03



(10)

Comment: PACKAGING RESOURCE #1

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

07/01/03

Job Completion



C Lot 101103

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:4
A	04.12.13	NEW ISSUE	

RELEASED
86/02/02

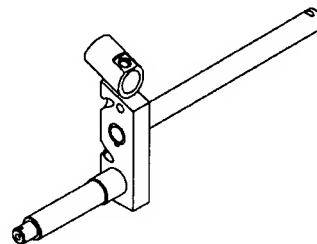
D3354-9 HANDLE
SOCKET (1)
POSITION D3354-9
2" FROM THIS END
OF ϕ TOWARD
D3354-3 WHEEL SHAFT

D3354-1 INNER
SHAFT (1)

D3354-7 LEFT
ARM PLATE (1)

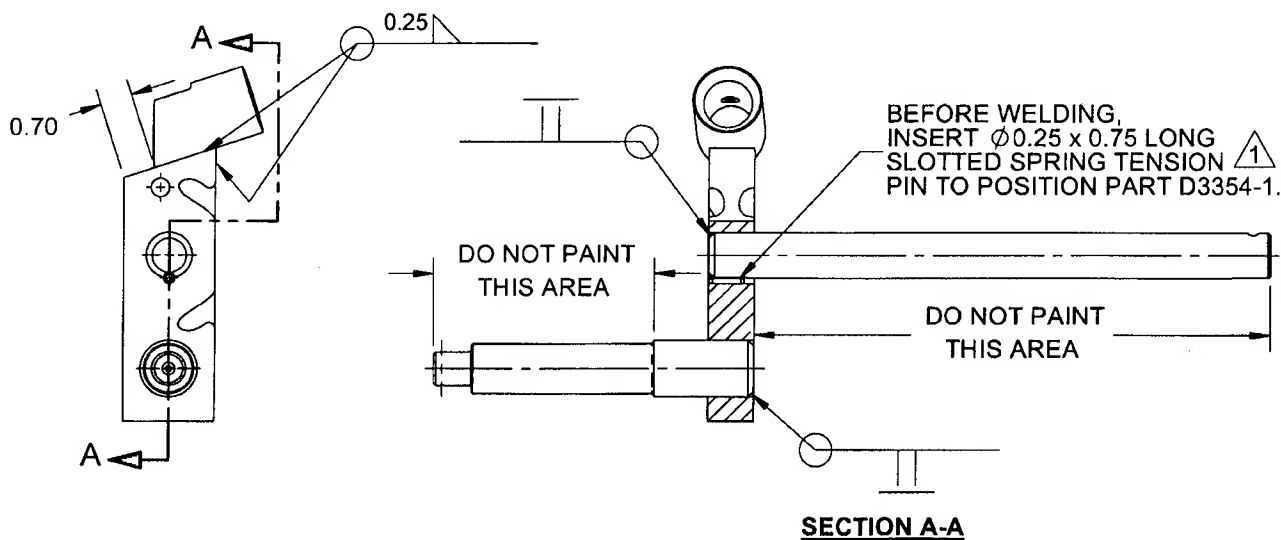
D3354-3 WHEEL
SHAFT (1)

SLOTTED SPRING
TENSION PIN, $\triangle 1$
 $\phi 0.25 \times 0.75$ LONG



**D3354-042 MIRROR
ARM WELDMENT**

D3354-041 LEFT ARM WELDMENT



NOTES:

- 1) POSSIBLE SUPPLIER: SPAENAUR, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005.4-3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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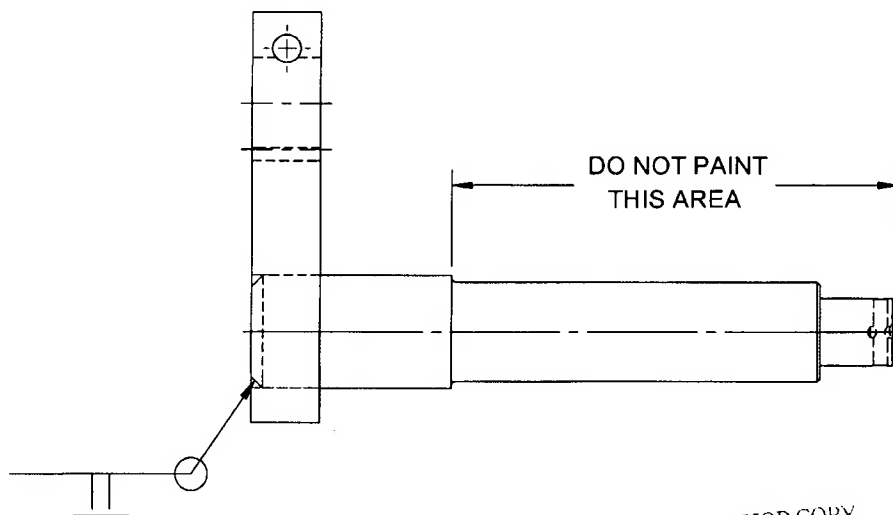
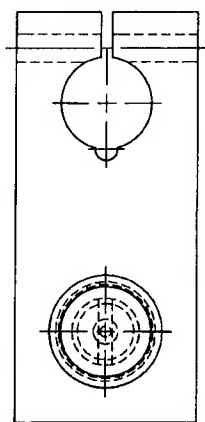
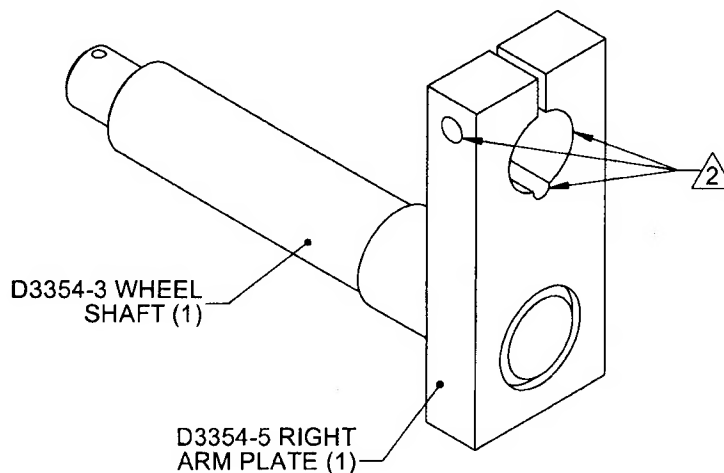
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:2

RELEASED
06/03/14

218



D3354-043 RIGHT ARM WELDMENT

NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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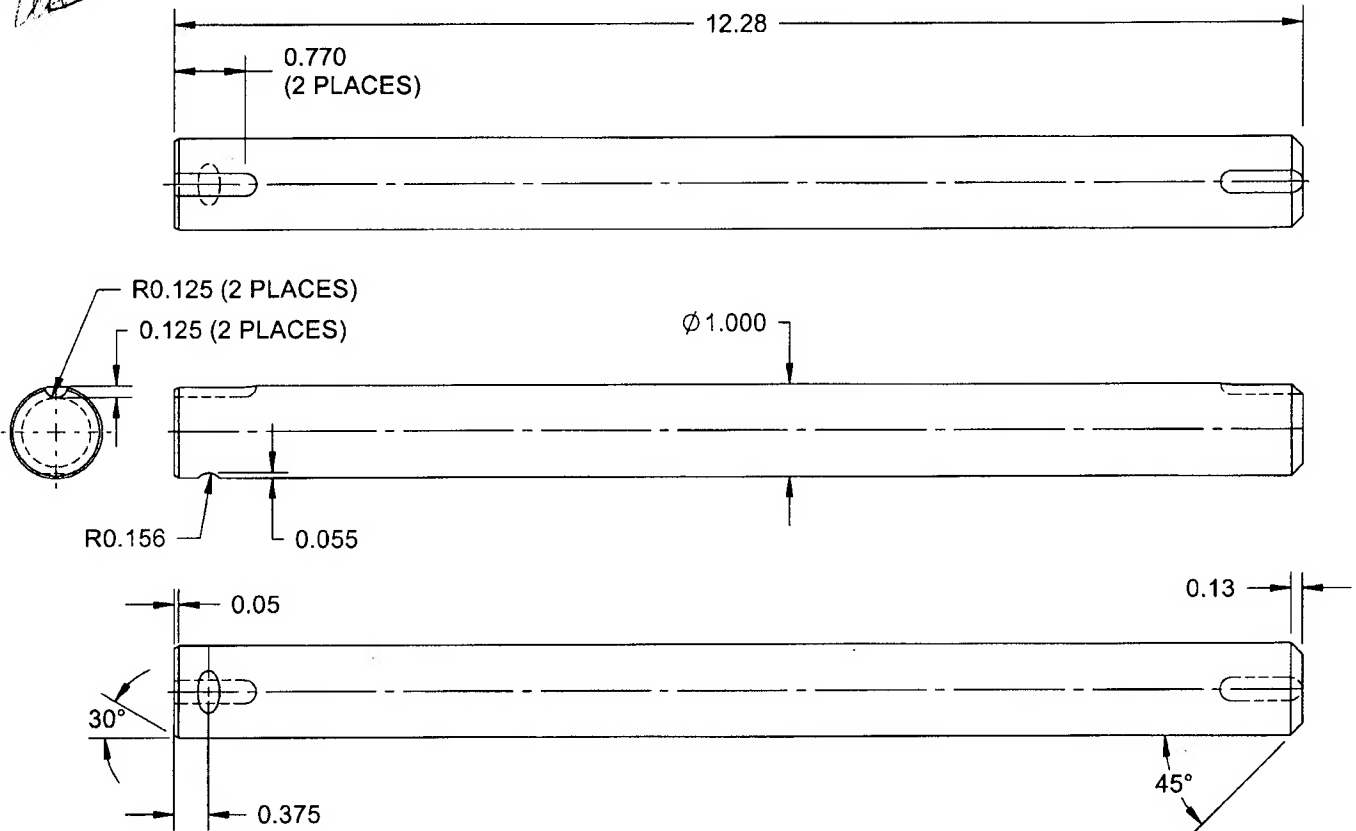
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RELEASED
36/03/07**D3354-1 INNER SHAFT**

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NOTES:

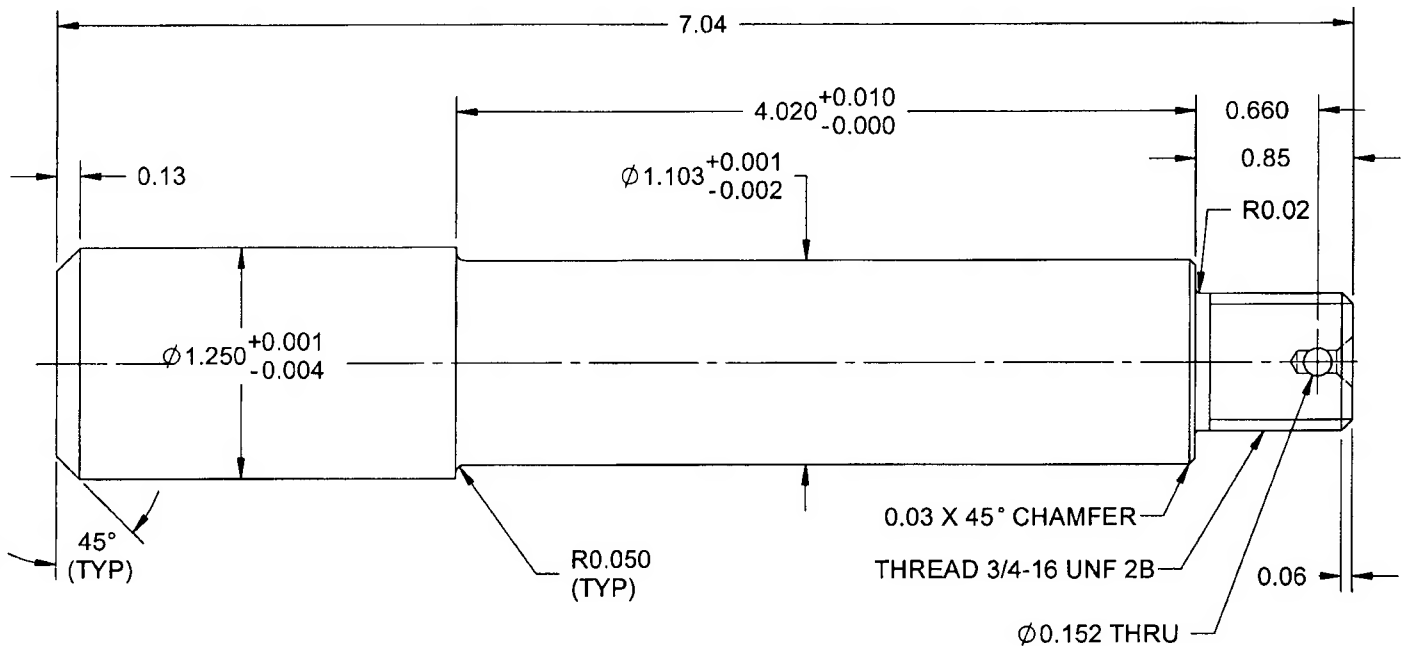
- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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[Signature]**D3354-3 WHEEL SHAFT**

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NOTES:

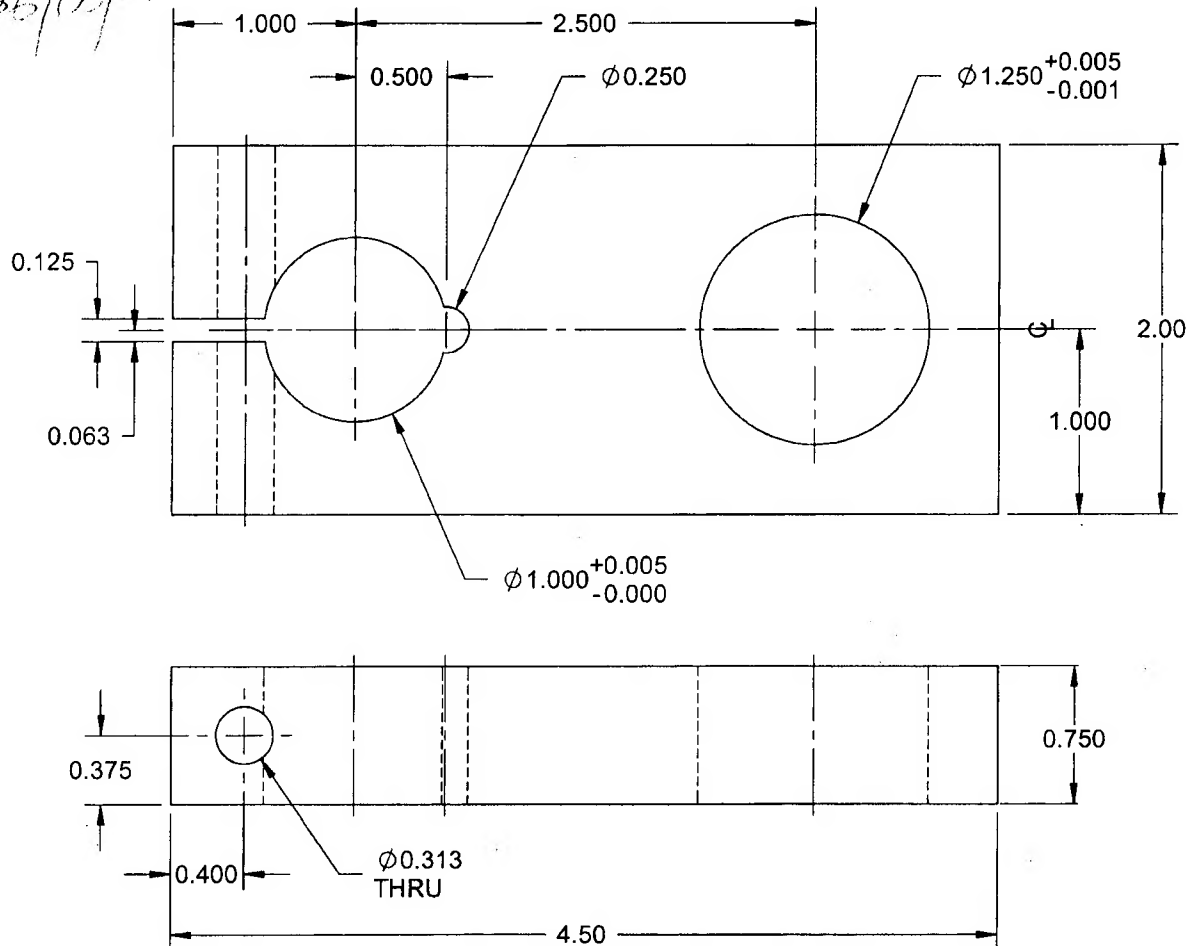
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- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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RELEASED
06/03/14**D3354-5 RIGHT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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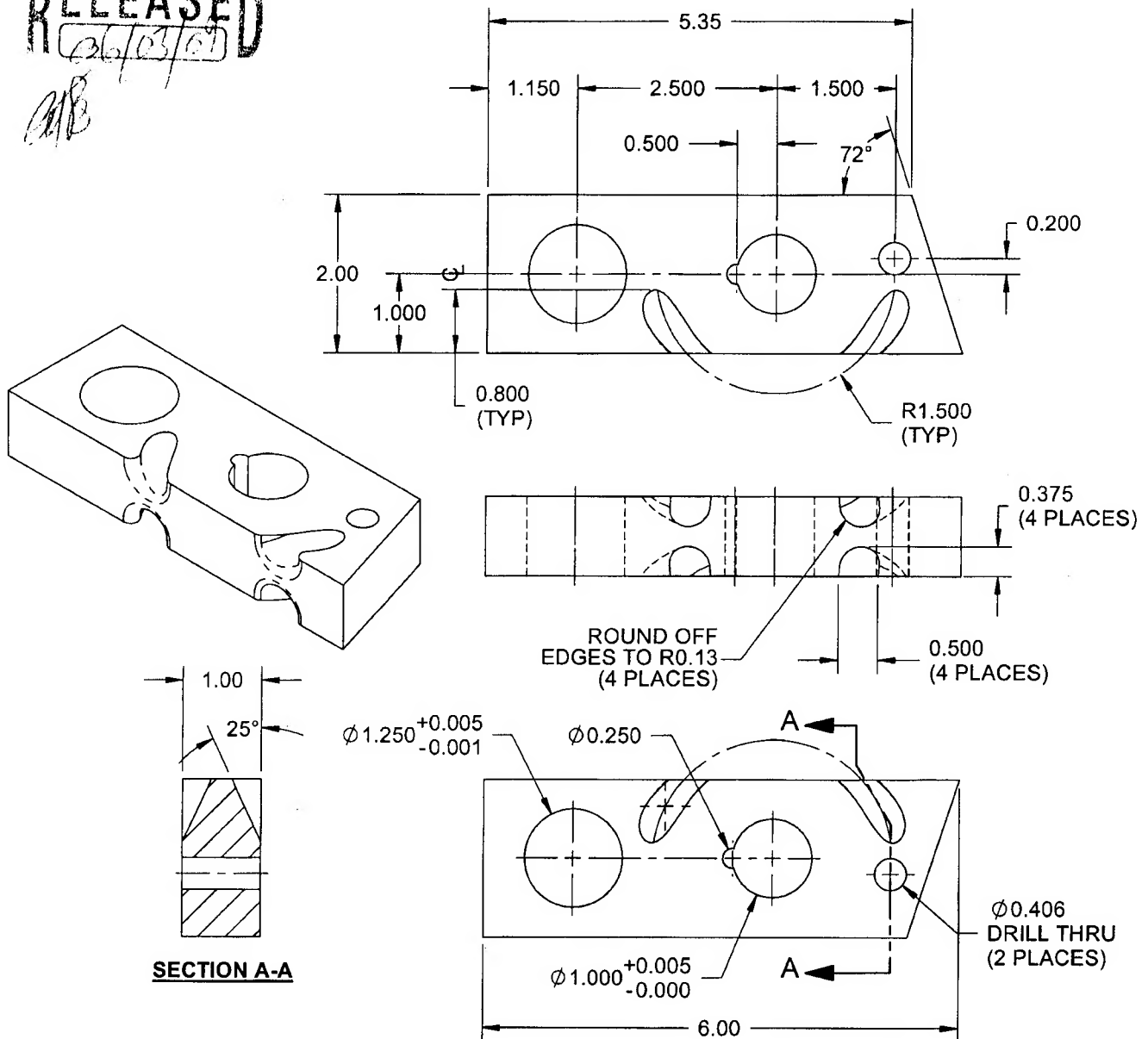
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DATE 04.12.13		TITLE LEFT ARM WELDMENT	SCALE 1:2

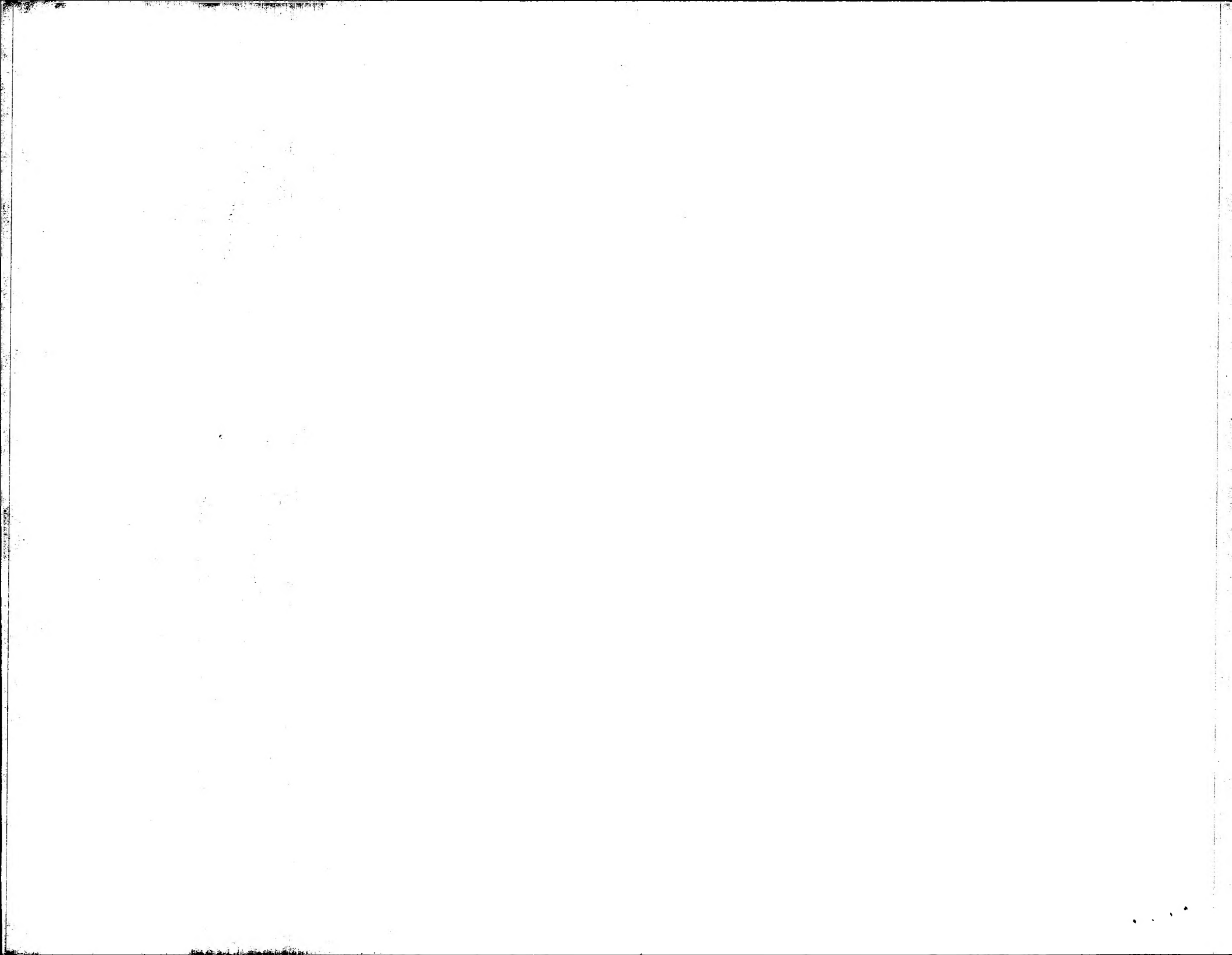
RELEASED
26/03/09
[Signature]**D3354-7 LEFT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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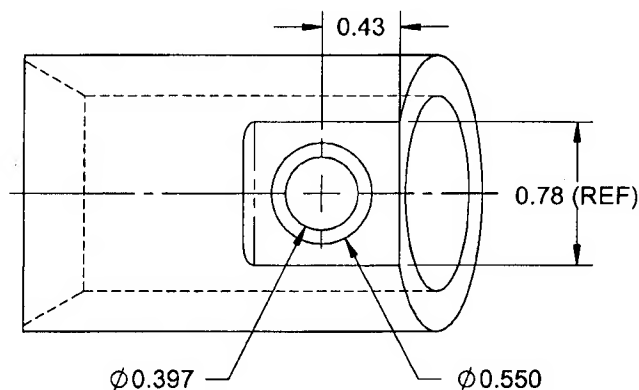
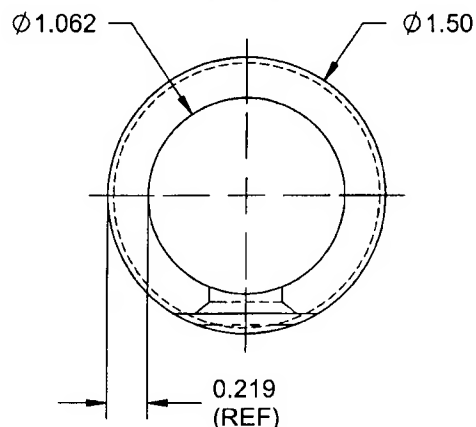
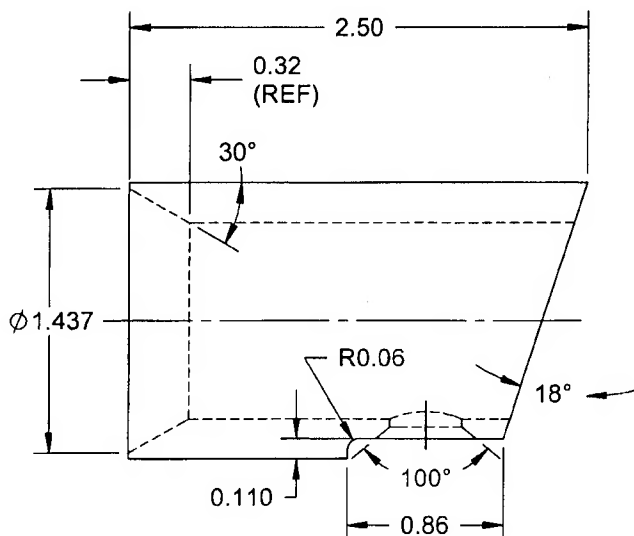
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DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:1

**D3354-9 HANDLE SOCKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
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